

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006623**Date Inspected:** 04-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

OBG Blast Bay 2-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of Cross Beam 3 after grit blasting. During Caltrans visual inspection two cracks were observed on Floor beam to side plate stiffener Complete Joint Penetration welds SP222-001-093 and SP224-001-056. ZPMC Quality Control stated. ZPMC Quality Control (QC) relayed that a Critical Weld Repair report would be submitted for Caltrans engineering review and ZPMC would research Nondestructive Testing performed on Cross beam 3. An Incident report was issued for above mentioned cracks. Please see the attached photos below.

OBG Segment Assembly area-

QA Inspector observed the following work in progress: FCAW welding of weld joint 015 located on SEG013C. ZPMC welder was identified as 220067. ZPMC QC is identified as Xue Fa Wen. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

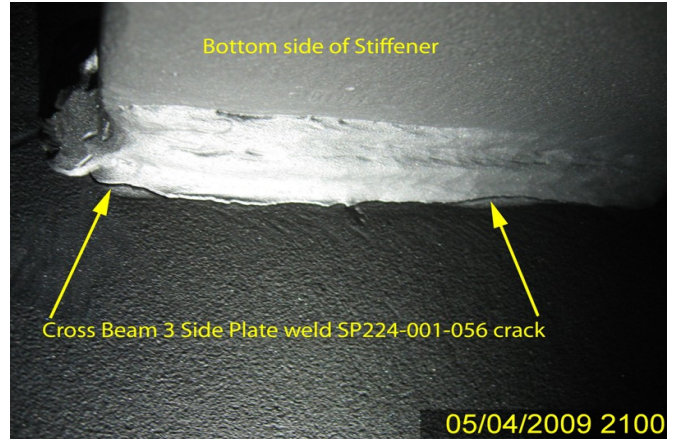
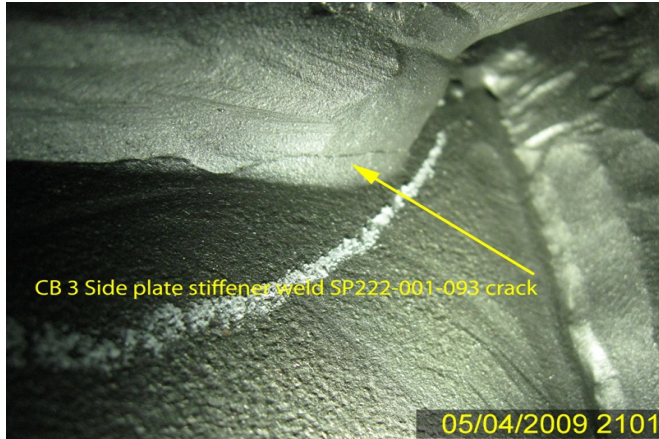
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---



### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150 0042 2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

---